

04/04

Date: Wednesday, 3/21/2007 3:48:25 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SS WEARSHOE KITS
Job Number	: 31416		
Estimate Number	: 12803		
P.O. Number	: N/A	Part Number	: DSI9367013
This Issue	: 3/21/2007 S.O. No. : N/A	Drawing Number	: DSI9367 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 3/28/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.03.22</u>		
Comment	: Est Rev:A New Issue 07-03-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI9367-013 CHG 001

KS 07.03.22

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D356413	WEARSHOE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WEARSHOE

Batch: B31398 ✓

4.0	D356613	GASKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GASKET

Batch: B31399 ✓

5.0	D35371	WEARPAD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WEARPAD

B31163 ✓ 1X B30757 ✓ 3X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:48:25 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 31416

Part Number: DSI9367013

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: B31400-✓ ✓

7.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Wearpad

Batch: B31401 ✓

8.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: B31402-✓ ✓

9.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

INSERT

Batch: M1102649 ✓

10.0

NAS1330C3KB266

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

INSERT

Batch: M117905-✓ ✓

11.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

BOLT

Batch: M1103691 ✓

12.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: M1103481 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/21/2007 3:48:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 31416

Part Number: DSI9367013

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

AN960C10L

washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

washer

Batch: 1102602 - ✓

*EP 04/04/04* (4)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*CS 07/04/04* (4)

Comment: INSPECT 100% KITS FOR COMPLETENESS

*CS 7/4/4* (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi9367-013

Location: \_\_\_\_\_

PPP Rev: A

*CS 07/04/04*

(4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

*CS 07/04/04*

Job Completion



*CS 07/04/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9367	REV. A SHEET 1 OF 3
DATE 07.02.09		TITLE STAINLESS STEEL WEARSHOE KITS	SCALE NTS
A	07.02.09	NEW ISSUE	

**DART SERVICE INSTRUCTION**  
**TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. B**  
REF. FAA STC: SR01583SE  
REF. CANADIAN STC: SH05-37 ISSUE 1

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade to stainless steel wearshoes the following kit can be obtained from Dart:

QTY -011	Part Number	Description
X	DSI 9367-011	WEARSHOE KIT
1	D3564-1	WEARSHOE (REPLACES D3460-1)
2	D3566-1	GASKET
1	D3564-3	WEARSHOE (REPLACES D3460-3)
1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade the fwd and aft sections of their float skid tubes, the following kits can be obtained from Dart:

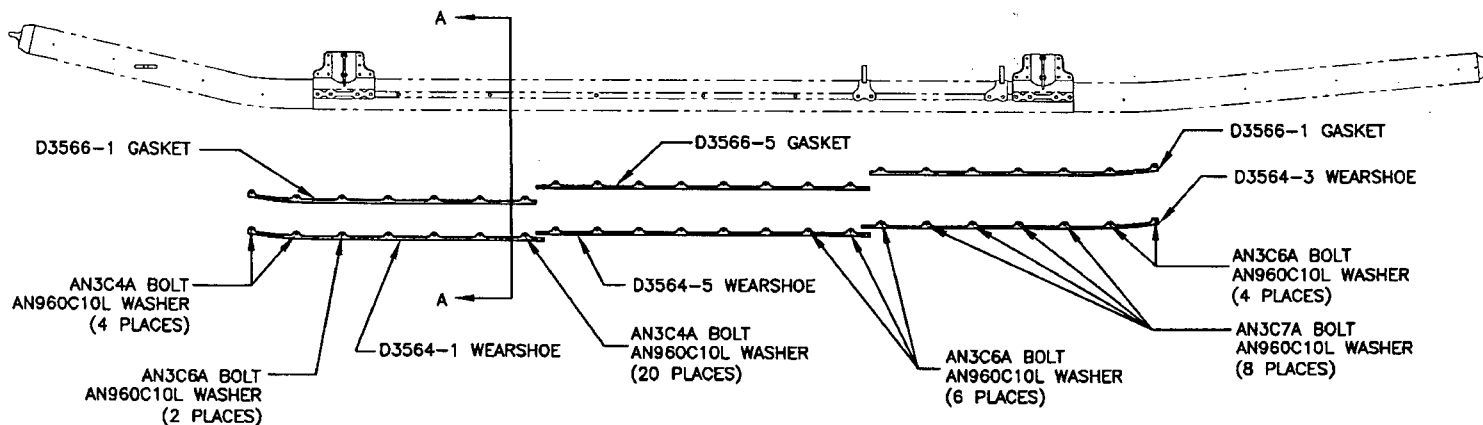
QTY -013	Part Number	Description
X	DSI 9367-013	WEARSHOE KIT
1	D3564-13	WEARSHOE
1	D3566-13	GASKET
1	D3537-1	WEARPAD
1	D3553-1	GASKET
1	D3537-7	WEARPAD
1	D3553-3	GASKET
10	NAS1330C3KB166	INSERT
4	NAS1330C3KB266	INSERT
10	AN3C4A	BOLT
4	AN3C5A	BOLT
14	AN960C10L	WASHER

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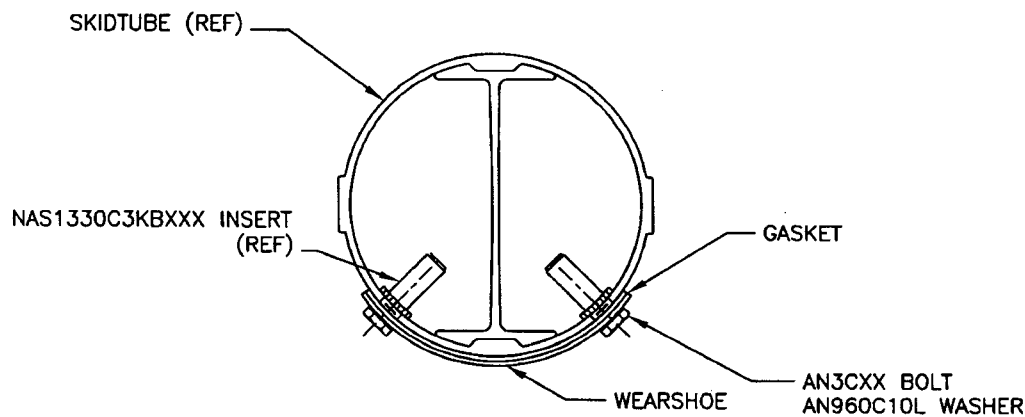
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**DART**



**FIGURE 1: DSI 9367-011 WEARSHOE KIT**



**SECTION A-A  
(TYPICAL INSTALLATION)**

**DSI 9367-011 Wearshoe Kit Installation Procedure**

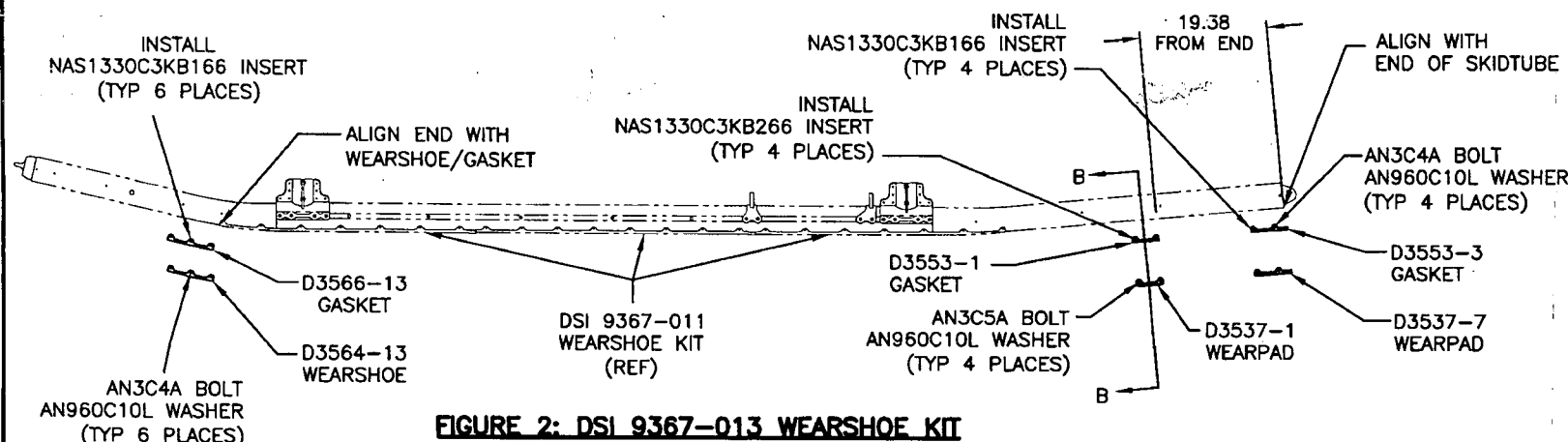
- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Remove existing D3460-1/-3 and D2577-5 wearshoes by removing AN3C hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.  
**Note:** Removing the wearshoes will require breaking a layer of sealant between the wearplates and the skidtube.  
 Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.  
 Install D3564-1/-3/-5 wearshoes complete with D3566-1/-5 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).  
 Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

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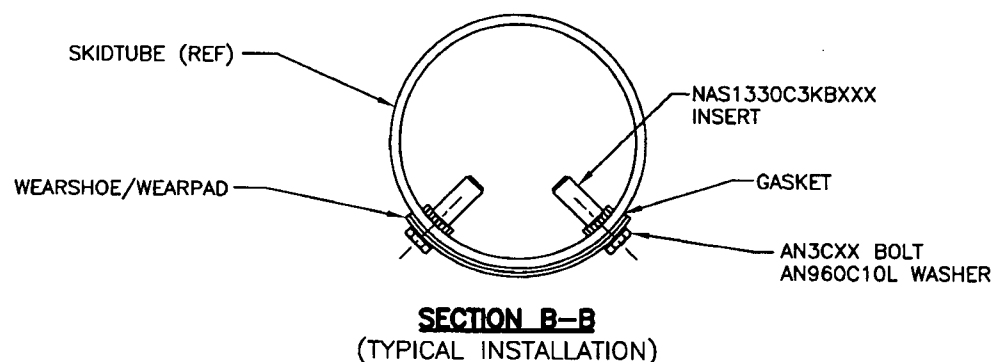
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.02.09	TITLE	DSI 9367	REV. A
			STAINLESS STEEL WEARSHOE KITS	SHEET 2 OF 3
				SCALE
				NTS



**DART**



**FIGURE 2: DSI 9367-013 WEARSHOE KIT**



**SECTION B-B  
(TYPICAL INSTALLATION)**

**DSI 9367-013 Wearshoe Kit Installation Procedure**

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Check skidtube for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Locate the wearshoe/wearpads and gaskets as shown in Figure 2.
- 4) Using the wearshoe/wearpad/gasket as a template, drill  $\varnothing 0.125$ " holes in the center of the wearshoe/wearpad obrounds. Remove the wearshoe/wearpad/gasket and drill qty (14)  $\varnothing 0.250$ " -  $\varnothing 0.257$ " holes for installing the required inserts, countersink all holes to  $\varnothing 0.391 \times 100^\circ$ . Deburr and remove swarf from inside of skidtube.  
Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install NAS1330C3KB inserts using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant prior to installation. Install D3564-13 wearshoes and D3537-1/-7 wearpads complete with D3566-13 and D3553-1/-3 gaskets using AN3C bolts as applicable. All bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts 15-25 in-lbs (1.7-2.8 N-m).  
Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.02.09	DRAWING NO.	DSI 9367	REV. A
		TITLE	STAINLESS STEEL WEARSHOE KITS	SHEET 3 OF 3
				SCALE
				NTS

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